

Date: Monday, 11/6/2006 2:39:06 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350 SKIDTUBE EXTRUSION (BENT)  
 Job Number : 29327  
 Estimate Number : 10997  
 P.O. Number : N/A Part Number : D26003BENT  
 This Issue : 11/6/2006 S.O. No. : N/A Drawing Number : D2600 REV D1  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : D1  
 Previous Run : 26787 Material : NM  
 Due Date : 11/20/2006 Qty: 20 Um: Each  
 Written By :  
 Checked & Approved By : 06/11/07  
 Comment : Est. B02.11.28 Reformat KJ

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D26003120 Extrusion Round 3" 350



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Extrusion Bent

Pick:

Qty	Part Number	Description
1	D2600-3	Extrusion

Batch

BAG205

DP 6-12-6

40

2.0 BENDING BENDING MACHINE



Comment: BENDING MACHINE

Deburr one end of extrusion

Drill #30 pilot holes using DT8689

Open holes to 5/16" and deburr

Bend using CNC bending machine as per program 2750.C and Folio FT003.

Use 5/16 locator pin on buggy "A".

Check fit to Jig DT8150

> DP/JB 06/12/06 (40)

> ELAP 06/12/06

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect work to Step 6 Ensure fit to Jig DT8150

> JB 12-13 (40)

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

LG EL 06/12/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: PP Date: 06/12/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/6/2006 2:39:06 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 SKIDTUBE EXTRUSION (BENT)

Job Number: 29327

Part Number: D26003BENT

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*06/12/14*

Job Completion



*u 06.12.14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>DM</i>	DRAWN BY <i>DM</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>SA</i>	DRAWING NO. D2600	REV. 0 SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01.04.17	ADD PART NUMBERS & DIE NUMBERS <i>4 GP</i>	

**RELEASED**  
98.08.25 DS

### GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi  
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED  
TO ASTM STANDARD B221 BY AN APPROVED TESTING  
FACILITY TO ENSURE THAT THE BATCH MEETS THE  
ABOVE MINIMUM MECHANICAL PROPERTIES.

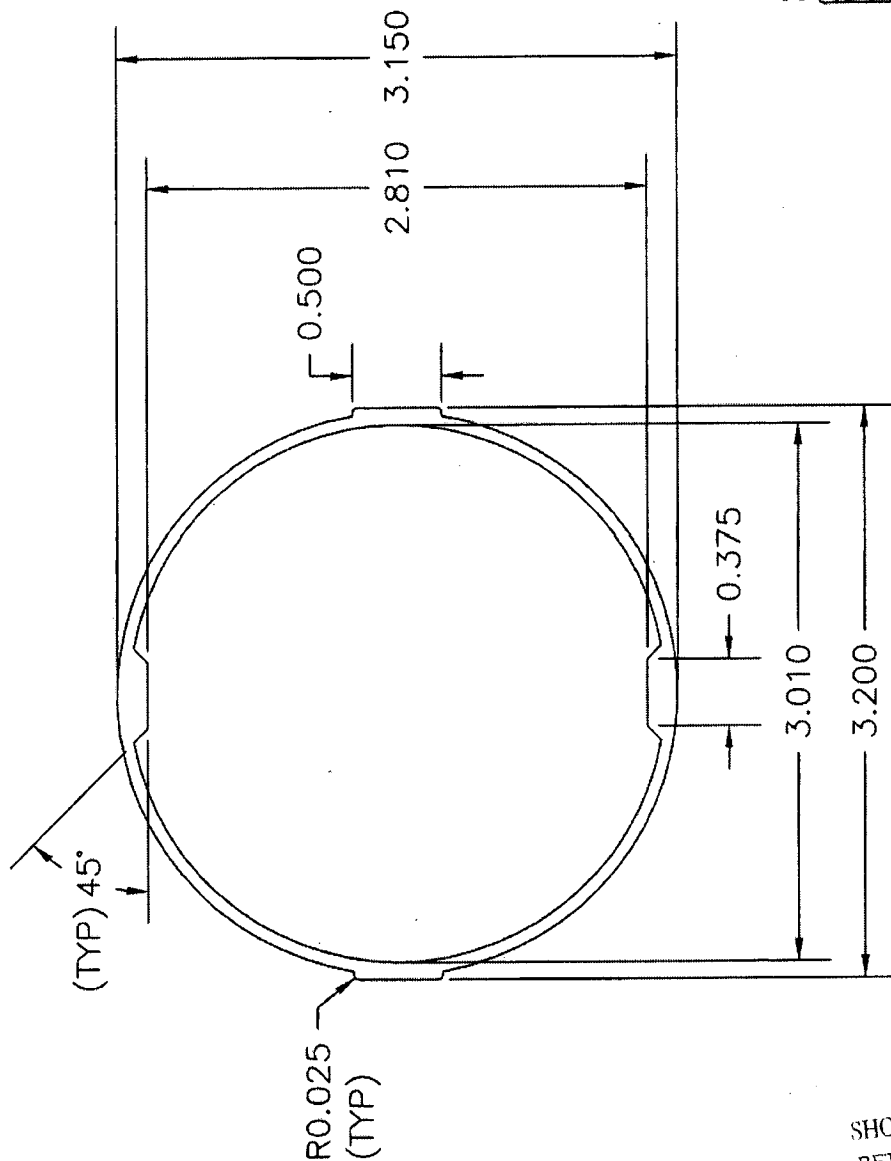
2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

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WORK ORDER  
NO. *29327*



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DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

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98.8.25 DS



D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870  
OR BON L DIE # 897121 (PREFERRED CHOICE)  
PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)

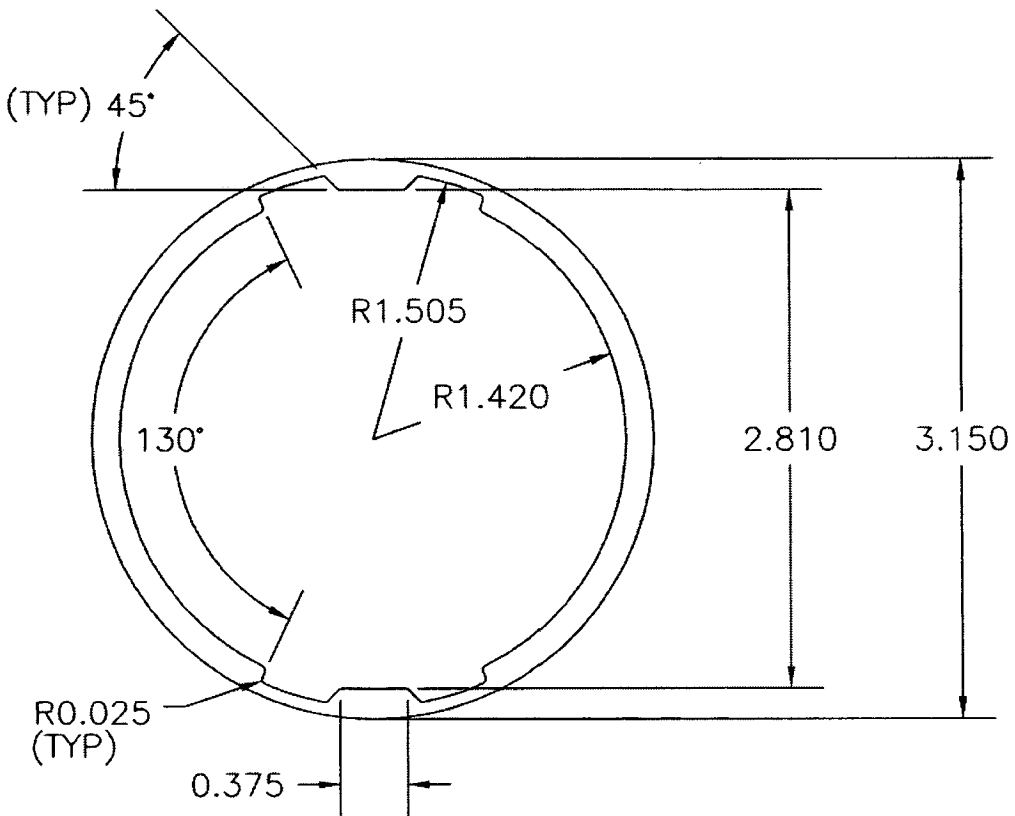
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NO. 29327



**DART**



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DATE	98.08.20			D2600	SHEET 3 OF 5
				TITLE	SCALE
				EXTRUSION	1:1



D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859

OR BON L DIE # 897122 (PREFERRED CHOICE)

PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)



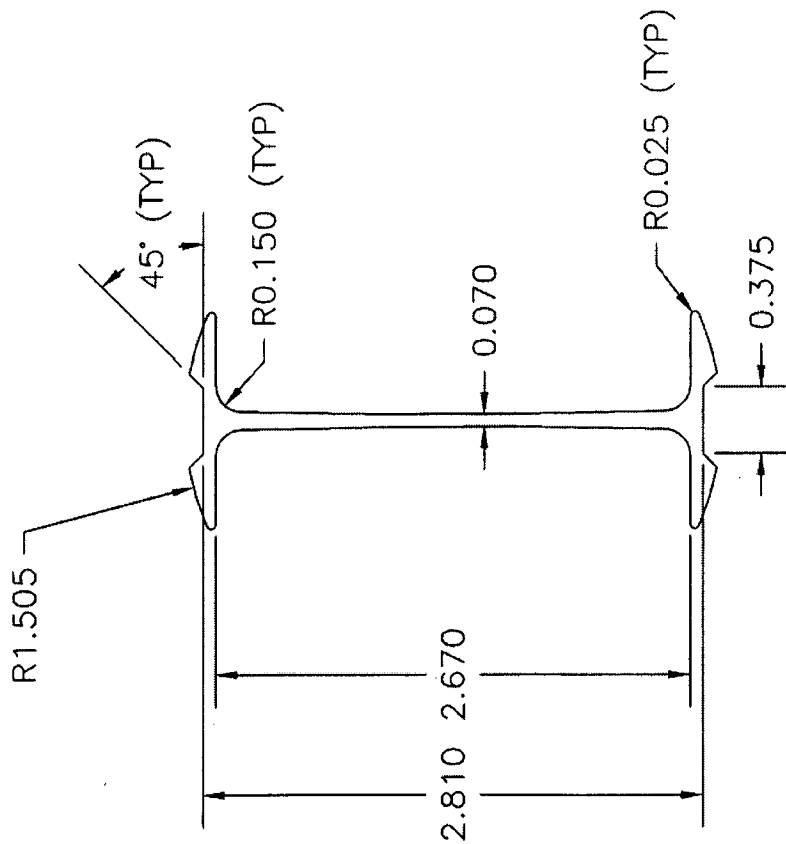
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98.8.25 DS



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CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D. SHEET 4 OF 5
DATE 98.08.20	TITLE EXTRUSION		SCALE 1:1

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98.8.25 DS



D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871  
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES  
(EG. D2600-5-108 IS 108" LONG)

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NO. 29327

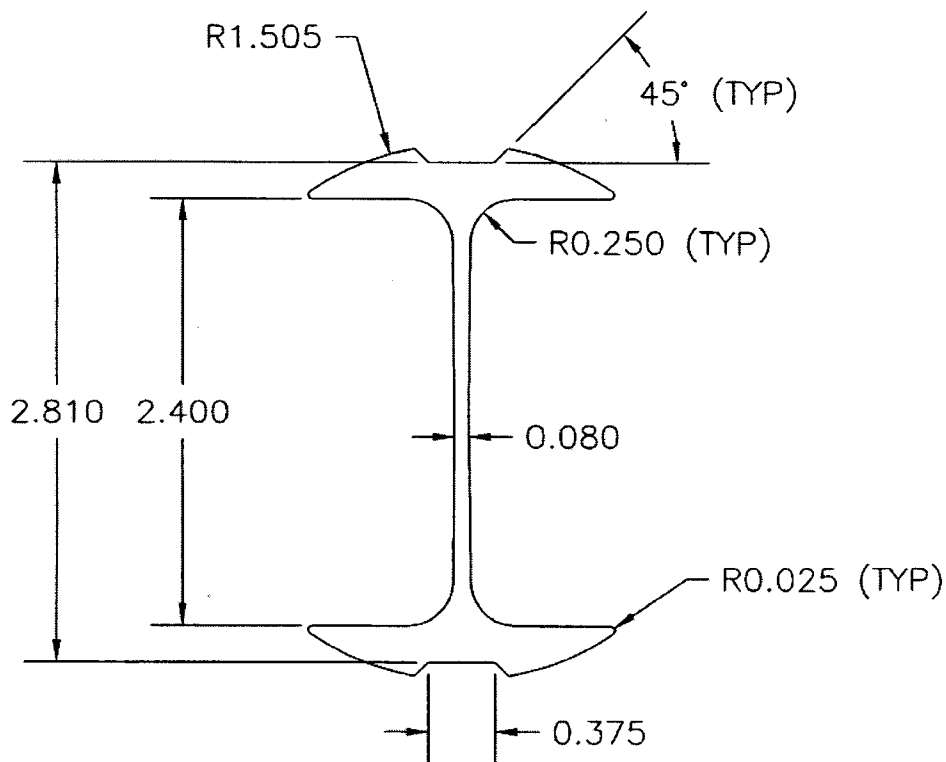


**DART**



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DATE 98.08.20	TITLE EXTRUSION	REV. D SHEET 5 OF 5 SCALE 1:1

**RELEASED**  
98.8.25 DS



D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872  
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES  
(EG. D2600-7-125 IS 125" LONG)



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